

Date: Friday, 21/12/2007 2:45:24 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BUSHING
Job Number	: 36534		
Estimate Number	: 10518		
P.O. Number	: <i>N/A</i>	Part Number	: D28063
This Issue	: 21/12/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D2806 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 34019	Material	: <i>N/A</i>
Written By	: _____	Due Date	: 15/01/2008 Qty: 50 Um: Each
Checked & Approved By	: _____		
Comment	: Est:B 05.03.11 Part now turned KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6H1000	6061-T6 1" HexBar
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Comment: Qty.: 0.0962 f(s)/Unit Total : 4.8090 f(s)

6061-T6 Hex Bar 1.0"

Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11) 1.00" Hex Bar

(M6061T6H1.000)

Batch: *M105238*

K.A

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA105 and Dwg D2806

2-Tumble

H.A / 9m 08/01/02

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

H.A / 9m 08/01/02

4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE

Drill as per Dwg D2806

AD 08/01/08 50

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SA 08/01/08 30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 10 Date: 28/11/14
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(50)

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

8/1/11 SD 08-01-11

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(50X)

Comment: INSPECT ALODINE

8/1/11 SD

8.0

PACKAGING 1

PACKAGING RESOURCE #1



(50X)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 48

8/1/11 SD

9.0

QC21

FINAL INSPECTION/W/O RELEASE



(50)

Comment: FINAL INSPECTION/W/O RELEASE

08-01-11

Job Completion



08-01-11

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

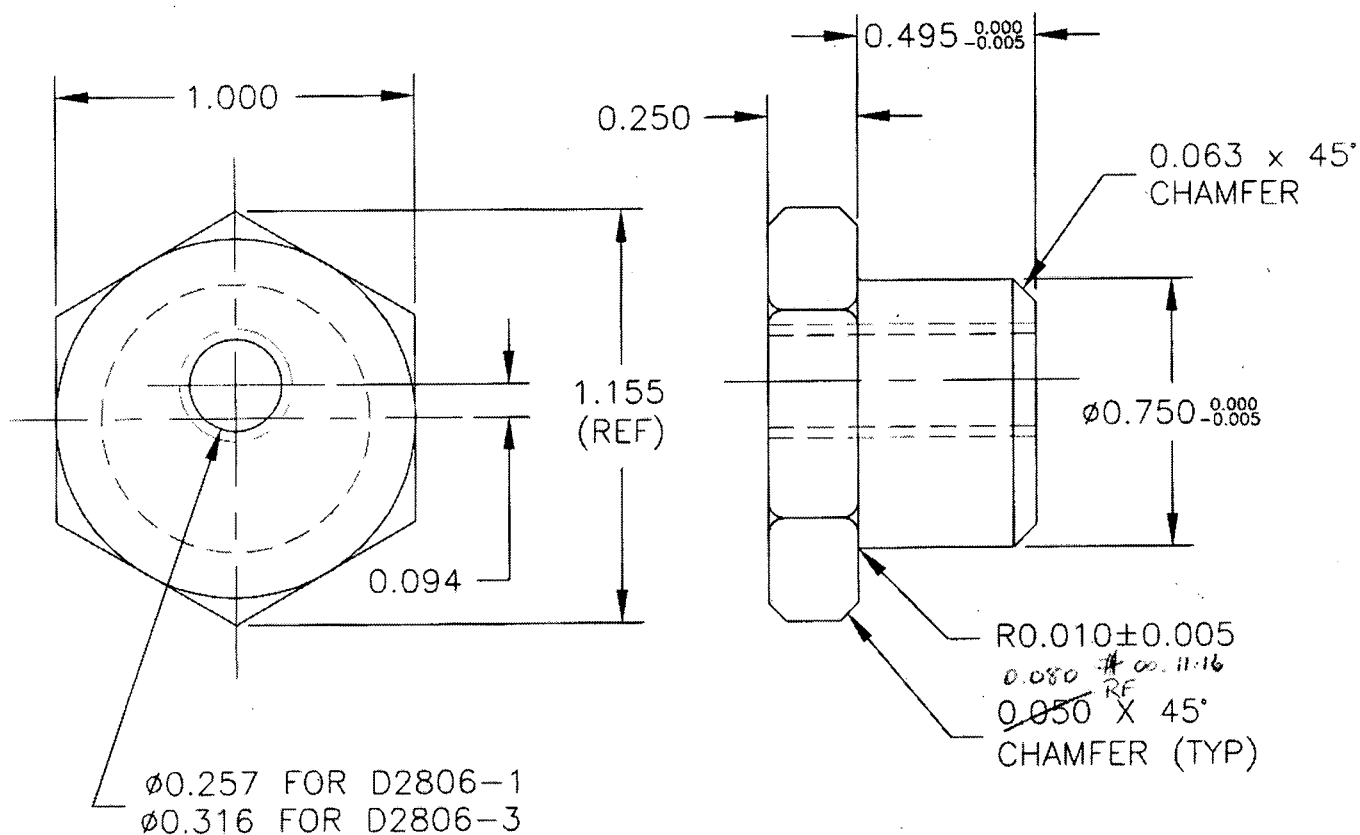
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED #	DRAWING NO. D2806	REV. A SHEET 1 OF 1
DATE 00.11.08		TITLE BUSHING	SCALE 2:1
A	00.11.08	NEW ISSUE	

RELEASED
00.11.12 #



D2806-1 (DRILL $\phi 0.257$ HOLE)
D2806-3 (DRILL $\phi 0.316$ HOLE)

W/O 36534

MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) OR (QQ-A-225/8)
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries